

1. 5/24

SPLIT

6

DART AEROSPACE LTD	Work Order:	23329
Description: Hi-Step Leg Assembly	Part Number:	D2582
Dwg: D2582 Rev. A; D2322 Rev. C; D2279 Rev. D	Qty:	20 11
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller (minimum lots of 5) <i>FF 02.10.22</i>	<i>FF</i>	05.05.20	20
2	MV	Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <i>M17347</i>	<i>En</i>	05/06/16	30
3	MV	Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: <i>M17347</i>	<i>En</i>	05/06/16	30
4	MV	Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick (M5052H32S.080) Identify as D2278 Batch: <i>M17790</i> (Note: make two legs per assembly)	<i>En</i>	05/06/16	20
5	MV	Cut blank: (3.400") +/-0.020" Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000) Identify as D2280 Batch: <i>M11853</i> (Note: make two spacers per assembly)	<i>En</i>	05/06/16	20
6	MV	Machine as per folio D2322, use stack of 15	<i>En</i>	05/06/17	29
7	MV	Deburr to take measurement	<i>En</i>	05/06/17	29
8	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	29
9	QC8	Second inspection	<i>En</i>	05/06/17	29
10	MV	Machine as per folio D2279, use stack of 15	<i>En</i>	05/06/17	29
11	MV	Deburr to take measurement	<i>En</i>	05/06/17	30
12	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	30
13	QC8	Second inspection	<i>En</i>	05/06/17	30
14	MV	Machine as per folio D2278, use stack of 10	<i>En</i>	05/06/16	40
15	MV	Deburr to take measurement	<i>En</i>	05/06/16	40
16	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/16	40
17	QC8	Second inspection	<i>En</i>	05/06/16	40
18	MV	Machine per folio D2280 and Dwg D2280	<i>En</i>	05/06/17	40
19	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	40
20	MV	Tumble. Deburr any rough edges after tumbling.	<i>En</i>	05/06/17	40

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MV
20

Photo

RELEASED
05/21/22

Photo

DART AEROSPACE LTD	Work Order:	23329C
Description: Hi-Step Leg Assembly	Part Number:	D2582
Dwg: D2582 Rev. A; D2322 Rev. C; D2279 Rev. D	Qty:	22 11
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																												
21	QC8	Second inspection	FF	05.06.17	40																												
22	GA	Deburr D2322, D2279 and D2278 stack	FF	05.07.4	427																												
23	GB	Bend D2322 and D2279 per Dwg D2322 and D2279	FF	05.07.4	27																												
24	QC5	Inspect work to Step 23	2	05-07-04	27																												
25	FP	Chemical conversion as per QSI 005 D2278, D2279, D2280, D2322	FF	05-07-05	18																												
26	GA	Assemble as per Dwg D2582 and Identify as D2582 Assembly <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2278</td><td>Leg</td><td>B23329</td></tr><tr><td>1</td><td>D2279</td><td>Spacer</td><td>B23329</td></tr><tr><td>2</td><td>D2280</td><td>Spacer</td><td>B23329</td></tr><tr><td>1</td><td>D2322</td><td>Spacer</td><td>B23329</td></tr><tr><td>22</td><td>MS20470AD4-4</td><td>Rivet</td><td>M17405</td></tr><tr><td>4</td><td>MS20470AD4-5</td><td>Rivet</td><td>M1663</td></tr></table>	Qty	Part Number	Description	Batch	2	D2278	Leg	B23329	1	D2279	Spacer	B23329	2	D2280	Spacer	B23329	1	D2322	Spacer	B23329	22	MS20470AD4-4	Rivet	M17405	4	MS20470AD4-5	Rivet	M1663	SB	05/07/07	11
Qty	Part Number	Description	Batch																														
2	D2278	Leg	B23329																														
1	D2279	Spacer	B23329																														
2	D2280	Spacer	B23329																														
1	D2322	Spacer	B23329																														
22	MS20470AD4-4	Rivet	M17405																														
4	MS20470AD4-5	Rivet	M1663																														
27	QC5	Inspect work to Step 26	2	05-07-07	11																												
28	GA	Identify and Stock	AD	05-07-08	11																												
29	AC	Cost / part 44.91	AR	05/07/07	11																												
30	DC	Close W/O 40.89 Inspect Level 21	47	05/07/11	11																												

Rev	Date	Change	Revised By	Approved
A	96.07.08	New Issue		
B	99.02.10	Re-format	DM	
C	01.10.16	Added new rivet and new dwg (mpp2165)	SM	
D	02.05.14	Added rivet option	NG	
E	02.10.07	Re-format; Incorporated D2278, D2279, D2280, D2322	KJ RF	4

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06/10/22

PART

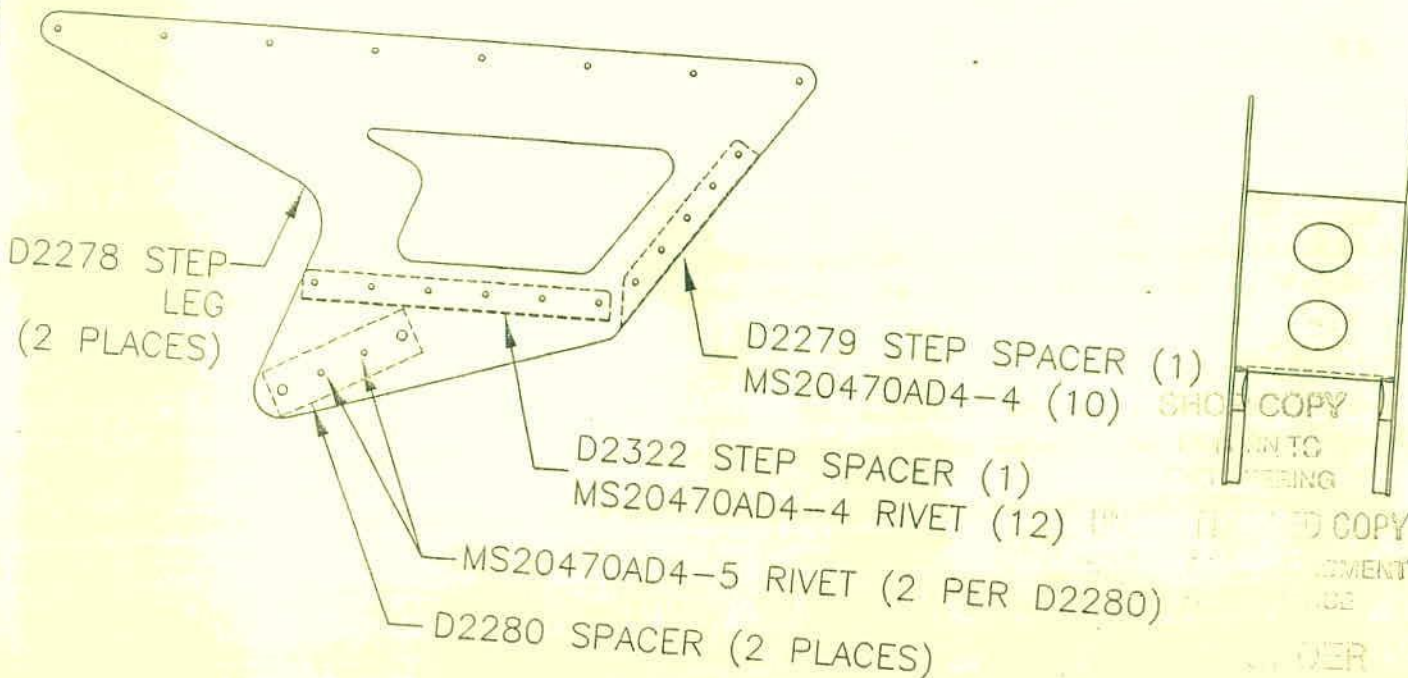


Part

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D2582	REV. A
DATE 01.10.05		TITLE STEP LEG ASSEMBLY	SHEET 1 OF 1
A	01.10.05	NEW ISSUE	SCALE 1:5

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET



D2582

23329
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01-10-16

